

for D130-701-043 basket

Work Order ID 152694

152694

Page 1

Friday, November 04, 2016 1:11:50 PM

Item ID: D4038-044 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Angle Assy Aft RH
Start Date: 11/7/2016 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 11/9/2016 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: em Date: 11/11/14 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4038	E								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.03							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.06							
Small Fab	Assemble as per dwg								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
6
9-89

NOV 08 2016

1 FF

NOV 09 2016



send for test fit
do not paint - see Stan.

DAS
38
9-89

NOV 09 2016

POSITIVE RECALL

EFFECTIVE 11/11/14 AUTH em

RELEASED 11/11/14 DATE 12-01-24

DTG

DQA:

Date:

2017-02-16



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed

Date:

FEB 15 2017

Work Order update only

Work Order: <u>152694</u> Part No. <u>D4038-044</u> NCR No. <u>17-6282</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☒ Large Fab ☐ Composite ☐ Supplier ☐					
Date: <u>17-01-24</u>		Step #: <u>120</u>		QTY Effective: <u>(1)</u>			MRB (QSI042) Approval <u>DAS</u> <u>9</u> <u>9-89</u>		
Description Work Order Deviation				Disposition				Completed By <u>BEB 2017</u> <u>17.02.02</u>	
part use for test fit, damage found to from installation.				Remove D4038-B / D4038-12 buff out marking a/c line continue work from seg 110 add new hardware.				Lead hand / Supervisor Approval Verification <u>PD 17.02.03</u>	
								QC / QA Coordinator Approval <u>PD 17.02.03</u>	
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Set up ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ ☒ Training Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ ☒ Finish Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐					
OTHER: _____									

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
121 *121* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo ***MASK INTERIOR OF BLOCKS AND MASK ALL HOLES WITHOUT BOLTS*** START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ <i>11/13/13 10:05</i> <i>10:35</i> <i>OK</i>	0.00 0.02				1	0	1702-2	<i>33</i> <i>9-89</i>
122 *122* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1			<i>DAS</i> <i>38</i> <i>9-89</i> FEB 02 2017
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST</i> Memo	0.00 0.00				1			<i>DAS</i> <i>21</i> <i>9-89</i> FEB 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		
140									
QC	Memo	0.02							
Quality Control									
							DAS 21 9-89		FEB 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

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Page 1

Work Order ID: 152694

152694

Parent Item: D4038-044

D4038-044

Parent Item Name: Angle Assy Aft RH

Start Date: 11/7/2016

Required Date: 11/9/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-04-21 JLM VERIFIED BY:EC IPP
Rev:B 11.01.31 as per dwg rev.c DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4038-4 *D4038-4* Angle, Aft, RH		Manufactured	No			100	Each	2.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				ST513				2					
				144231				2					
D4038-8 *D4038-8* Block		Manufactured	No			100	Each	2.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				ST072				2					
				144237				2					
D4038-12 *D4038-12* Block		Manufactured	No			100	Each	2.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				st073				2					
				144236				2					

**

NOV 08 2016

DAS
6
9-89

**

NOV 08 2016

DAS
6
9-89

**

NOV 08 2016

DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Picklist Print

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152694

Parent Item: D4038-044

D4038-044

Parent Item Name: Angle Assy Aft RH

Start Date: 11/7/2016

Required Date: 11/9/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-14A

Purchased

No

100

Each

122.0000

2

2

AN3-14A

Bolt

**

NOV 0 8 2016

DAS

6

9-89

Location

Loc Qty

Loc Code

over003

80

m134852

0

m135600

30

m135966

50

ST349

42

m134852

3

m135056

39

MS21042L3

Purchased

No

100

Each

1,665.000

2

2

MS21042L3

Nut

**

NOV 0 8 2016

DAS

6

9-89

Location

Loc Qty

Loc Code

FP001

7

M130922

7

GA

216

m134360

108

m135135

108

OVER007

600

m135945

600

ST303

842

m135530

239

m135600

3

m135767

600

DQA: _____ Date: _____



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Picklist Print

Friday, November 04, 2016 1:11:49 PM

Page 3

Work Order ID: 152694

152694

Parent Item: D4038-044

D4038-044

Parent Item Name: Angle Assy Aft RH

Start Date: 11/7/2016

Required Date: 11/9/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

100

Each

1,172.000

4

4

NAS1149D0363.J

NOV 08 2016
DAS
6
9-89

Washer

Location

Loc Qty

Loc Code

GA

336

m134055

336

ST263

836

m135864

836

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

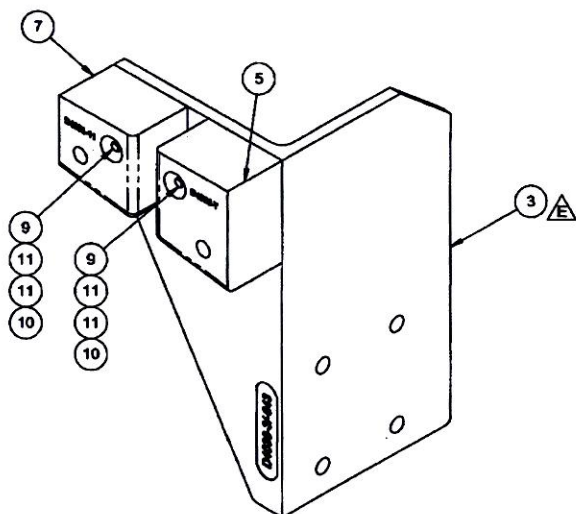
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

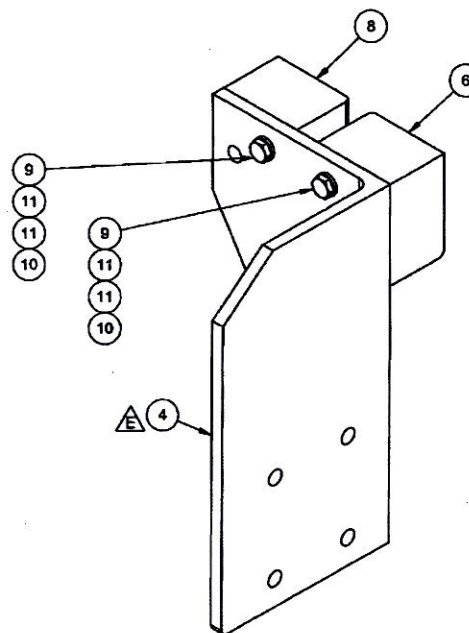
ITEM NO.	QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
1	X		D4038-043	ANGLE ASSEMBLY, AFT, LH
2		X	D4038-044	ANGLE ASSEMBLY, AFT, RH
3	1		D4038-3	ANGLE, AFT, LH
4		1	D4038-4	ANGLE, AFT, RH
5	1		D4038-7	BLOCK
6		1	D4038-8	BLOCK
7	1		D4038-11	BLOCK
8		1	D4038-12	BLOCK
9	2	2	AN3-14A	BOLT
10	2	2	MS21042L3	NUT
11	4	4	NAS1149D0363J	WASHER (AN960JD10)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152694

Em 16/11/4



D4038-043 ANGLE ASSEMBLY, AFT, LH



D4038-044 ANGLE ASSEMBLY, AFT, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -043 - 1.96 lbs
-044 - 1.74 lbs

RELEASED
2011-04-21
JP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4038	REV. E
MFG. APPR.			SHEET 2 OF 14
APPROVED		TITLE BRACKET	SCALE
DE APPR.			NTS
DATE	11.04.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	